

Work Order ID 138656

Friday, November 06, 2015 12:28:24 PM

138656

BLUE

Page 1

Item ID: D2932-1BL Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Saddle LH Out, 206
 Start Date: 11/6/2015 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 11/20/2015 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: JMF Date: 5-11-06 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2932	Rev C

100	HAAS CNC VERTICAL MACHINING #1	0.01				6	0		DAS 20 9-89 15-11-19
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100

HAAS 1

HAAS CNC vertical machine #1

Memo

Program part number and batch number.1-Inspect part number and batch number are programmed correctly.2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per

110	CONVENTIONAL MILLING MACHINE	0.00				6	0		DAS 20 9-89 15-11-19
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110

Mill Conv

Conventional Milling Machine

Memo

Machine Keyway and inspect per attached dimension sheet

120	QC1- Inspection performed by CMM	0.00				6	0		DAS 08 9-89
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120

QC

Quality Control

Memo

0.00

15/11/24

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	QC8- Inspect parts - second check	0.00							
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130

QC

Memo

Quality Control

140	Chemical Conversion Coat per QSI005 4.1	0.00							
-----	---	------	--	--	--	--	--	--	--

140

HandFinish

Memo

Hand Finishing

150	Spray Painting per QSI005 4.2	0.00							
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150

SprayPaint

Memo

Spray Painting

SPRAY PAINT BLUE

BATCH: 11111

Primer: 13242

Paint: 132641

Clear: 129271

DAS

41

9-89

15-11-30

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
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				OTHER :							

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC14- Inspect Spray Paint	0.00							DAS 38 9-89
160						(6)			DEC 01 2015
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location <u>S7392</u>	0.00				6			DAS 6 9-89
170									DEC 01 2015
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180						MCS			DEC 01 2015
QC	Memo	0.01							
Quality Control									

SA 20151201

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
		OTHER : ☐							

Picklist Print

Page 1

Friday, November 06, 2015 12:28:24 PM

Work Order ID: 138656

138656

Parent Item: D2932-1BL

***D2932-1BL ***

Parent Item Name: Saddle LH Out, 206

Start Date: 11/6/2015

Required Date: 11/20/2015

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: B00.06.26New DWG rev, (mpp 2069)EC

IPP Rev:C As per Rev C 07-03-19 JLM

IPP REV:D

15.10.09 ADDED BL DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6101-003

Manufactured No

100

Each

74.0000

1

6

DAS

D6101-003

6

20

15-11-18

Saddle Billet, 7075

Location

Loc Qty

Loc Code

MAT045

74

134038

14

135957

40

136764

20

6

DQA: _____ Date: _____



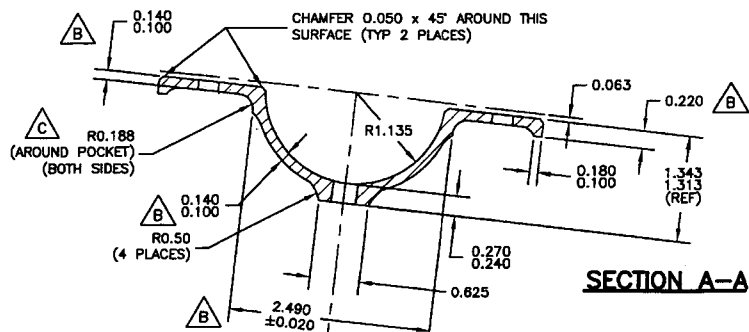
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

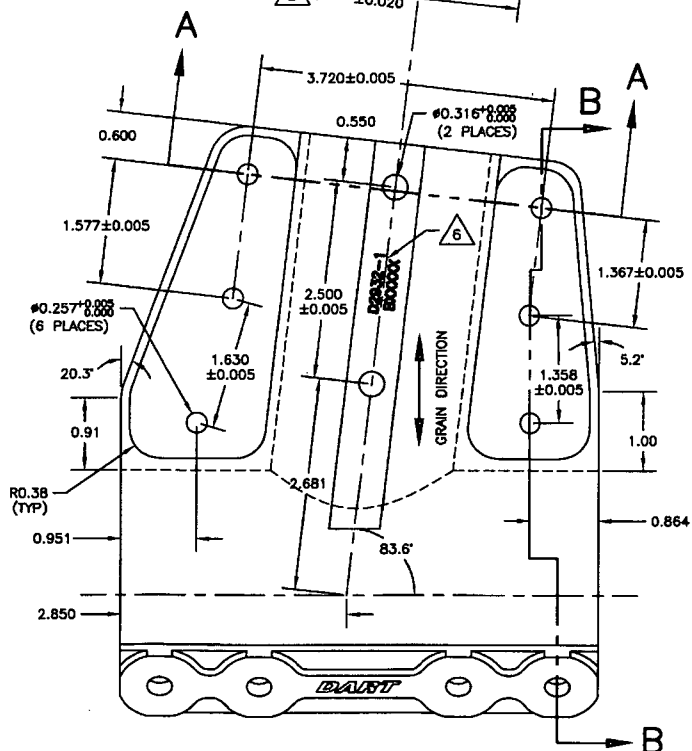
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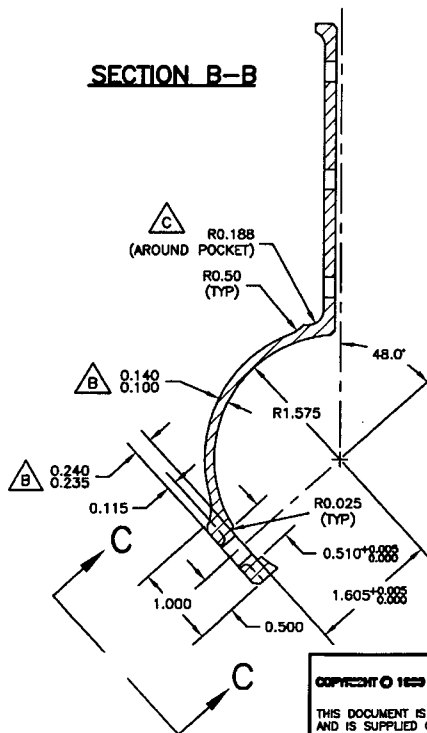
Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
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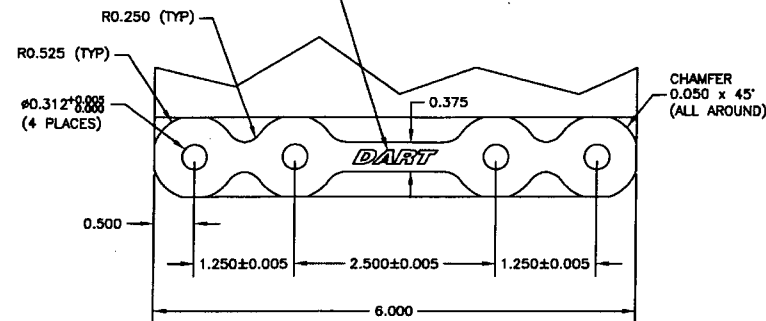
SECTION A-A



SECTION B-B



ENGRAVE DART LOGO TO MAX DEPTH OF 0.005 WITH MIN RAD 0.250



VIEW C-C

D2932-1 LH SADDLE (SHOWN)
D2932-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12) (MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED	APPROVED	DRAWING NO. D2932
DATE	06.11.09	TITLE SADDLE OUTSIDE
		REV. C SHEET 1 OF 1 SCALE 2:3

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RELEASED

07-02-12

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																					
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DART AEROSPACE LTD		Work Order: 138656
Description: 206 Saddle, Outboard, Left side		Part Number: D2932-1
Inspection Dwg: D2932 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.113	.116	.114	.114		
B	0.100	0.140		.113	.117	.118	.118		
C	0.100	0.140		.114	.115	.116	.117		
D	0.210	0.230		.217	.216	.216	.219		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.512	.512	.512	.512		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.259	.259	.259	.259		
L	0.312	0.317		.314	.314	.314	.314		
M	0.235	0.240		.238	.238	.238	.238		
N	0.100	0.140		.119	.119	.119	.119		
O	0.540	0.560		.546	.548	.548	.546		
P	0.490	0.510		.498	.500	.500	.501		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.490	2.490	2.490	2.490		
S	0.240	0.270		.250	.253	.250	.253		
T	0.100	0.180		.135	.135	.135	.135		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.316	.316	.316	.316		
X	1.125	1.145		1.1369	1.1374	1.1374	1.1356		
Y	1.565	1.585		1.5748	1.5752	1.575	1.574		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	9-89
Date:	15-11-18

Audited by:	JK
Date:	15-11-25

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : ☐					

DART AEROSPACE LTD	Work Order: 138656
Description: 206 Saddle, Outboard, Left side	Part Number: D2932-1
Inspection Dwg: D2932 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	5X	6X	X	X		
A	0.100	0.140		.117	.117				
B	0.100	0.140		.119	.119				
C	0.100	0.140		.117	.118				
D	0.210	0.230		.220	.221				
E	1.245	1.255		1.250	1.250	WSON			
F	1.245	1.255		1.250	1.250	WSON			
G	2.495	2.505		2.500	2.500				
H	0.510	0.515		.512	.512				
I	1.572	1.582		1.577	1.577				
J	2.495	2.505		2.500	2.500				
K	0.257	0.262		.259	.259				
L	0.312	0.317		.314	.314				
M	0.235	0.240		.238	.238				
N	0.100	0.140		.119	.120				
O	0.540	0.560		.546	.547				
P	0.490	0.510		.501	.501				
Q	3.715	3.725		3.720	3.720				
R	2.470	2.510		2.490	2.490				
S	0.240	0.270		.252	.251				
T	0.100	0.180		.135	.135				
U	1.625	1.635		1.630	1.630				
V	1.362	1.372		1.367	1.367				
W	0.316	0.321		.316	.316				
X	1.125	1.145		1.1357	1.139				
Y	1.565	1.585		1.5734	1.5743				
Z	0.178	0.198		.188	.188				
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									

Accept/Reject

Measured by: 20
Date: 15-11-19

Audited by: SK
Date: 15-11-25

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	



Part Number: D2932-1	Rev: C	- Page 1 -
Description: SADDLE OUTSIDE	Inspection Dwg: D2932	Work Order: 138656

Item Ref.	Nominal	Tolerance	No. Piece_1 Actual	No. Piece_2 Actual	No. Piece_3 Actual	No. Piece_4 Actual	
1	0.120	+0.010/-0.010	0.121	0.121	0.120	0.120	
D2	0.050	+0.010/-0.010	0.052	0.051	0.052	0.052	
3	0.063	+0.010/-0.010	0.058	0.057	0.058	0.058	
4	0.220	+0.010/-0.010	0.220	0.220	0.219	0.222	
5	1.328	+0.015/-0.015	1.329	1.328	1.329	1.328	
D6	0.140	+0.040/-0.040	0.135	0.135	0.135	0.135	
D7	0.120	+0.020/-0.020	0.113	0.117	0.118	0.118	
D8	0.255	+0.015/-0.015	0.250	0.253	0.250	0.253	
D9	0.625	+0.010/-0.010	0.635	0.635	0.635	0.635	
D10	2.490	+0.200/-0.200	2.490	2.490	2.490	2.490	
D11	0.120	+0.200/-0.200	0.113	0.116	0.114	0.114	
D12	0.188	+0.010/-0.010	0.188	0.188	0.188	0.188	
13	0.312	+0.005/0.000	0.313	0.313	0.313	0.313	
14	0.500	+0.010/-0.010	0.502	0.502	0.502	0.504	
15	1.250	+0.005/-0.005	1.250	1.250	1.251	1.250	
16	2.500	+0.005/-0.005	2.499	2.500	2.499	2.501	
17	1.250	+0.005/-0.005	1.251	1.249	1.250	1.250	
18	6.000	+0.010/-0.010	6.001	6.001	6.001	6.001	
D19	0.050	+0.010/-0.010	0.040	0.040	0.040	0.040	
20	0.063	+0.010/-0.010	0.065	0.064	0.064	0.065	
Ang21	48.000	+0.500/-0.500	47.846	47.890	47.838	47.845	
D22	0.510	+0.005/0.000	0.512	0.512	0.512	0.512	
23	1.605	+0.005/0.000	1.605	1.605	1.606	1.605	
24	0.500	+0.010/-0.010	0.502	0.504	0.504	0.504	
D25	1.000	+0.010/-0.010	1.003	1.003	1.003	1.003	
26	0.115	+0.010/-0.010	0.108	0.111	0.109	0.114	
D27	0.235	+0.005/0.000	0.238	0.238	0.238	0.238	
D28	0.120	+0.020/-0.020	0.114	0.115	0.116	0.117	
29	1.575	+0.010/-0.010	1.575	1.574	1.574	1.574	
30	3.720	+0.005/-0.005	3.719	3.719	3.719	3.719	
31	0.550	+0.010/-0.010	0.551	0.551	0.551	0.551	

Measured by:
GUILLAUME AUCLAIR

Date:
2015-11-24

Audited by:

Date:

SL
15-11-25



Part Number: D2932-1	Rev: C	- Page 2 -
Description: SADDLE OUTSIDE	Inspection Dwg: D2932	Work Order: 138656

Item Ref.	Nominal	Tolerance	No. Piece_1 Actual	No. Piece_2 Actual	No. Piece_3 Actual	No. Piece_4 Actual	
32	0.316	+0.005/0.000	0.316	0.316	0.316	0.316	
33	1.367	+0.005/-0.005	1.368	1.368	1.368	1.367	
34	5.200	+0.500/-0.500	5.201	5.210	5.208	5.208	
35	1.358	+0.005/-0.005	1.358	1.358	1.358	1.359	
36	0.864	+0.010/-0.010	0.864	0.862	0.864	0.863	
37	83.600	+0.500/-0.500	83.557	83.561	83.562	83.556	
38	2.681	+0.010/-0.010	2.681	2.681	2.680	2.681	
39	2.850	+0.010/-0.010	2.851	2.851	2.851	2.851	
40	0.951	+0.010/-0.010	0.952	0.952	0.953	0.953	
41	20.300	+0.500/-0.500	20.232	20.226	20.226	20.239	
42	1.630	+0.005/-0.005	1.630	1.630	1.629	1.629	
43	0.257	+0.005/0.000	0.258	0.257	0.258	0.258	
44	1.577	+0.005/-0.005	1.578	1.577	1.578	1.578	
45	0.600	+0.010/-0.010	0.598	0.598	0.598	0.597	
46	2.500	+0.005/-0.005	2.500	2.500	2.501	2.500	
47	1.135	+0.010/-0.010	1.134	1.133	1.133	1.133	

Measured by:
GUILLAUME AUCLAIR

Date:
2015-11-24

Audited by:

Date:

SL
15-11-25



Part Number: D2932-1	Rev: C	- Page 3 -
Description: SADDLE OUTSIDE	Inspection Dwg: D2932	Work Order: 138656

Item Ref.	Nominal	Tolerance	No. Piece_5 Actual	No. Piece_6 Actual			
1	0.120	+0.010/-0.010	0.121	0.122			
D2	0.050	+0.010/-0.010	0.052	0.052			
3	0.063	+0.010/-0.010	0.058	0.056			
4	0.220	+0.010/-0.010	0.222	0.223			
5	1.328	+0.015/-0.015	1.328	1.329			
D6	0.140	+0.040/-0.040	0.135	0.135			
D7	0.120	+0.020/-0.020	0.119	0.119			
D8	0.255	+0.015/-0.015	0.252	0.251			
D9	0.625	+0.010/-0.010	0.635	0.635			
D10	2.490	+0.200/-0.200	2.490	2.490			
D11	0.120	+0.200/-0.200	0.117	0.117			
D12	0.188	+0.010/-0.010	0.188	0.188			
13	0.312	+0.005/0.000	0.313	0.313			
14	0.500	+0.010/-0.010	0.503	0.503			
15	1.250	+0.005/-0.005	1.250	1.250			
16	2.500	+0.005/-0.005	2.499	2.500			
17	1.250	+0.005/-0.005	1.249	1.250			
18	6.000	+0.010/-0.010	6.001	6.001			
D19	0.050	+0.010/-0.010	0.040	0.040			
20	0.063	+0.010/-0.010	0.063	0.064			
Ang21	48.000	+0.500/-0.500	47.881	47.888			
D22	0.510	+0.005/0.000	0.512	0.512			
23	1.605	+0.005/0.000	1.605	1.605			
24	0.500	+0.010/-0.010	0.504	0.504			
D25	1.000	+0.010/-0.010	1.003	1.003			
26	0.115	+0.010/-0.010	0.116	0.116			
D27	0.235	+0.005/0.000	0.238	0.238			
D28	0.120	+0.020/-0.020	0.117	0.118			
29	1.575	+0.010/-0.010	1.574	1.573			
30	3.720	+0.005/-0.005	3.720	3.719			
31	0.550	+0.010/-0.010	0.550	0.551			

Measured by:
GUILLAUME AUCLAIR

Date:
2015-11-24

Audited by:

Date:

SL
15-11-25



Part Number:
D2932-1

Rev:
C

- Page 2/-

Description:
SADDLE OUTSIDE

Inspection Dwg:
D2932

Work Order:
138656

Item Ref.	Nominal	Tolerance	No. Piece_5 Actual	No. Piece_6 Actual			
32	0.316	+0.005/0.000	0.316	0.316			
33	1.367	+0.005/-0.005	1.368	1.367			
34	5.200	+0.500/-0.500	5.194	5.207			
35	1.358	+0.005/-0.005	1.358	1.359			
36	0.864	+0.010/-0.010	0.863	0.863			
37	83.600	+0.500/-0.500	83.563	83.559			
38	2.681	+0.010/-0.010	2.681	2.680			
39	2.850	+0.010/-0.010	2.851	2.851			
40	0.951	+0.010/-0.010	0.952	0.953			
41	20.300	+0.500/-0.500	20.228	20.231			
42	1.630	+0.005/-0.005	1.630	1.630			
43	0.257	+0.005/0.000	0.258	0.258			
44	1.577	+0.005/-0.005	1.577	1.577			
45	0.600	+0.010/-0.010	0.599	0.599			
46	2.500	+0.005/-0.005	2.500	2.501			
47	1.135	+0.010/-0.010	1.133	1.133			

Measured by:
GUILLAUME AUCLAIR

Date:
2015-11-24

Audited by:

Date:

SH
15-11-25